

AMENDMENTS TO THE CLAIMS

Claims 1-20 (Canceled).

21. (Currently Amended) An embossed laminar product comprising at least two layers of web material ~~(V1, V2, V1, V3)~~ wherein a first layer ~~(V1)~~ of said layers of web material has a background pattern made up of a first set of protuberances ~~(P2, P102, P1)~~, on which is superimposed an ornamental motif made up of a second set of protuberances ~~(P4, P104, P5)~~ of major dimensions and minor density with respect to the first set of protuberances and ~~in~~ to which ~~to~~ said first layer ~~(V1)~~ is coupled a second layer of said layers of web material ~~(V2, V3)~~ by means of glue ~~(C)~~, ~~characterized in that~~ adhesive; wherein said glue adhesive is applied in correspondence ~~of~~ to said second set of protuberances, ~~(P4, P104, P5)~~ the protuberances of said first set ~~(P2, P102, P1)~~ forming said background pattern being substantially free of glue adhesive ~~[[:]]~~.

22. (Currently Amended) ~~Sheet~~ The product as claimed in claim 21, ~~characterized in that~~ wherein said ~~two layers~~ ~~(V1, V2)~~ first layer and said second layer are glued adhered together by a colored glue adhesive.

23. (Currently Amended) ~~Sheet~~ The product as claimed in claim 21~~[[,]]~~ or 22, ~~characterized in that~~ wherein said second layer ~~of web material~~ ~~(V2, V3)~~ is embossed.

24. (Currently Amended) ~~Sheet~~ The product as claimed in claim 22, ~~characterized in that~~ wherein said second layer ~~(V2)~~ has an embossing comprising a third set of protuberances ~~(P6, P106)~~ of major dimensions and minor density with respect to ~~the~~ protuberances of said first set of protuberances ~~(P1, P102)~~ defining the background pattern on the first layer ~~(V1)~~.

25. (Currently Amended) ~~Sheet~~ The product as claimed in claim 24, ~~characterized in that~~ wherein the protuberances of said first set of protuberances ~~(P2, P102)~~ are squeezed at ~~the~~ positions of ~~the~~ protuberances of said second set of protuberances ~~(P4, P104)~~ of the first layer ~~(V1)~~.

26. (Currently Amended) ~~Sheet~~ The product as claimed in claim 24 or 25, ~~characterized in that said~~ wherein protuberances of the third set of protuberances ~~(P6, P106)~~ on the second layer ~~(V2)~~ are inserted inside ~~the~~ protuberances of said second set of protuberances ~~(P4, P104)~~ on said first layer ~~(V1)~~.

27. (Currently Amended) ~~Sheet~~ The product as claimed in ~~one or more of claims 24 to 26, characterized in that the~~ claim 24, wherein protuberances of the third set of protuberances ~~(P6, P106)~~ on the second layer ~~(V2)~~ are higher than ~~the~~ protuberances of the second set of protuberances ~~(P4, P104)~~ on the first layer ~~(V1)~~.

28. (Currently Amended) ~~Sheet~~ The product as claimed in ~~one or more of claims 24 to 27 characterized in that~~ claim 24, wherein said ~~two layers~~ first layer and said second layer are ~~glued~~ adhered together on at least some of the protuberances of the third set of protuberances ~~(P6,~~ P106) on said second layer ~~(V2)~~.

29. (Currently Amended) ~~Sheet~~ The product as claimed in ~~one or more of claims 24 to 27, characterized in that it~~ comprises claim 24, further comprising a third layer ~~(V3)~~ joined to the first layer and the second layer ~~layers~~ ~~(V1,~~ V2) at the protuberances of the second set of protuberances ~~(P104)~~ of said first layer ~~(V1)~~.

30. (Currently Amended) ~~Sheet~~ The product as claimed in claim 29, ~~characterized in that~~ wherein said third layer (V3) is embossed with a fourth set of protuberances ~~(P108)~~ arranged with ~~the same~~ a pattern as ~~the~~ common to a pattern of protuberances of the third set of protuberances ~~(P106)~~ on said second layer ~~(V2)~~, but ~~not so high~~ lower in height.

31. (Currently Amended) ~~Sheet~~ The product as claimed in claim 29 or 30, ~~characterized in that~~ wherein said third layer ~~(V3)~~ is ~~glued~~ adhered to said first layer ~~(V1)~~ on at least some ~~of the~~ protuberances of said second set of protuberances ~~(P104)~~.

32. (Currently Amended) ~~Sheet~~ The product ~~(N)~~ as claimed in claim 23, ~~characterized in that~~ wherein said

second layer ~~(V3)~~ comprises at least one background embossing ~~consisting of~~ including a plurality of third protuberances ~~(P3)~~ having minor dimensions and major density with respect to said ornamental motif.

33. (Currently Amended) ~~Sheet~~ The product as claimed in claim 32, ~~characterized in that the~~ wherein protuberances of each of said at least two layers of web material layer project from ~~the~~ a surface of ~~the~~ a corresponding layer facing ~~the~~ an interior of the ~~sheet material product~~.

34. (Currently Amended) ~~Sheet~~ The product as claimed in claims 32, ~~to 33, characterized in that~~ wherein said third protuberances ~~(P3)~~ in said second layer ~~(V3)~~ are squeezed at ~~the~~ positions of the second protuberances ~~(P5)~~ of the first layer, forming said ornamental motif.

35. (Currently Amended) ~~Sheet~~ The product as claimed in claim 34, ~~characterized in that, where it meets the~~ wherein protuberances ~~(P5)~~ forming said ornamental motif meet in the first layer ~~(V1)~~, said second layer ~~(V3)~~ has protuberances on ~~the~~ a surface facing opposite ~~that facing~~ the first layer ~~(V1)~~.

36. (Currently Amended) A device for ~~the production~~ of producing a web material ~~(N)~~ made up of at least two layers ~~(V1, V2, V1, V3)~~, comprising:

— a first embossing unit for generating on at least a first layer ~~(V1)~~ of said at least two layers a background

pattern made up of a first set of protuberances ~~(P2, P102, P1)~~;

- a second embossing unit for generating on said first layer ~~(V1)~~ an ornamental motif made up of a second set of protuberances ~~(P4, P104, P1)~~ of major dimensions and minor density with respect to the protuberances ~~(P2, P102, P1)~~ of said first set of protuberances and partially superimposed on said background pattern;

- ~~a glue~~ an adhesive applicator for applying ~~a glue~~ an adhesive for coupling a second layer to said first layer;

- ~~wherein characterized in that~~ said glue adhesive applicator applies said glue adhesive on the protuberances ~~(P4, P104, P5)~~ of said second set of protuberances, but not on the protuberances of said first set of protuberances forming said background pattern, and cooperates with said second embossing unit.

37. (Currently Amended) Device as claimed in claim 36, ~~characterized by~~ wherein a first pressure roller, ~~(5, 105)~~ which is common to said first embossing unit and said second embossing unit, ~~interacting~~ interacts with a first embossing cylinder and a second embossing cylinder ~~cylinders~~ ~~(1, 3, 101, 103)~~ carrying respective points ~~(1P, 3P, 101P, 103P)~~ on their cylindrical surfaces thereof for generating on the first layer ~~(V1)~~ said first set of protuberances and said second ~~sets~~ set of protuberances.

38. (Currently Amended) Device as claimed in claim 37, ~~characterized in that~~ wherein the points ~~(1P, 101P)~~ of the first embossing cylinder ~~(1, 101)~~ have greater density and smaller dimensions than the points ~~(3P, 103P)~~ of the second embossing cylinder ~~(3, 103)~~.

39. (Currently Amended) Device as claimed in claim 38, ~~characterized in that it comprises~~ further comprising a second pressure roller ~~(7, 107)~~ interacting with the second embossing cylinder ~~(3, 103)~~.

40. (Currently Amended) Device as claimed in claim 36, ~~characterized in that~~ wherein said first embossing unit comprises a first pressure roller ~~(5')~~ interacting with a first embossing cylinder ~~(1')~~ and ~~that~~ wherein said second embossing unit comprises a second embossing cylinder ~~(3)~~ interacting with a second pressure roller and a third pressure roller rollers ~~(5, 7)~~.

41. (Currently Amended) Device as claimed in claim 36, ~~characterized in that it comprises~~ further comprising:

- a ~~further~~ third embossing unit ~~(305, 307, 421, 423, 205, 207)~~, for a second layer ~~(V3)~~, said first embossing unit and said ~~further~~ third embossing unit generating in said first layer and said second ~~layers~~ layer a background pattern ~~consisting of~~ including a first set of protuberances ~~(P1, P3)~~.

42. (Currently Amended) Device as claimed in claim 41, ~~characterized in that~~ wherein said means for coupling together said at least two layers join the ~~two layers~~ first layer and the second layer at the positions of the protuberances of the second set of protuberances which form said ornamental motif.

43. (Currently Amended) Device as claimed in claim 41 or 42, ~~characterized in that~~ wherein said first embossing unit and said ~~further~~ third embossing unit for generating said background pattern on the first layer and on the second layer ~~(V1, V3)~~ each comprise a pair of embossing rollers, one roller of which ~~(1, 5, 201, 205)~~ is provided with points ~~(1P, 5P, 201P, 205P)~~ while the other ~~(3, 7, 203, 207)~~ another roller of which is provided with a yielding surface.

44. (Currently Amended) Device as claimed in claim 41 or 42, ~~characterized in that~~ wherein said means for coupling said ~~two layers consist of~~ first layer and said second layer include an embossing cylinder ~~(9, 209)~~ of the second embossing unit and a marrying roller ~~(13, 213)~~, said embossing cylinder ~~(9, 209)~~ being provided with points ~~(9P, 209P)~~ for generating the second set of protuberances forming said ornamental motif.

45. (Currently Amended) Device as claimed in claim 44, ~~characterized in that~~ wherein said marrying roller ~~(13)~~ has a substantially rigid cylindrical surface.

46. (Currently Amended) Device as claimed in claim 41 or 42, ~~characterized in that~~ wherein the first embossing unit for the first layer ~~(V1)~~ comprises a pair of embossing rollers ~~(401, 403)~~; ~~in that~~; the second embossing unit comprises an embossing cylinder ~~(409)~~, provided with points ~~(409P)~~ for generating the second set of protuberances ~~(P5)~~ forming said ornamental motif, and interacting with a pressure roller ~~(411)~~; and ~~in that~~ the further third embossing unit ~~(421, 423)~~ for the second layer ~~(V3)~~ comprises ~~a further~~ an embossing cylinder ~~(421)~~ provided with points ~~(421P)~~ and interacting with a pressure roller ~~(423)~~ having a yielding surface.

47. (Currently Amended) Device as claimed in claim 46, ~~characterized in that~~ wherein said means for coupling said at least two layers ~~consist of~~ includes said two first embossing cylinder and said second embossing cylinder ~~cylinders~~ ~~(409, 421)~~, which form ~~between them~~ therebetween a lamination area in which the points ~~(409P, 421P)~~ of the two first embossing cylinder and the second embossing cylinder ~~cylinders~~ interact with each other.

48. (Currently Amended) Device as claimed in ~~one or more of claims 36 to 47~~, ~~characterized in that~~ claim 36, wherein said second embossing unit has an embossing cylinder ~~(309, 409, 209)~~ with interchangeable points ~~(309P, 409P, 209P)~~.



49. (Currently Amended) Device as claimed in claim 41, ~~characterized in that~~ wherein the first embossing unit ~~(301, 303)~~ for the first layer ~~(VI)~~ comprises a roller ~~(301)~~ provided with points ~~(301P)~~ and interacting with a pressure roller ~~(311)~~ covered with yielding material, which interacts with an embossing cylinder ~~(309)~~ of the second embossing unit ~~(309, 311)~~.

50. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are higher than and partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern, said first set of protuberances and said second set of protuberances protruding from a common face of said first layer; and

- coupling by means of adhesive to said first layer of web material at least a second layer of web material,

- wherein the adhesive is applied, prior to said coupling of said first layer to said second layer, in areas corresponding to at least some protuberances of said second

set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern.

51. (New) The method according to claim 50 wherein the background pattern on the first layer of web material is provided by embossing in-line and before the embossing of the first layer for generating said ornamental motif.

52. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern,

- embossing a second layer of web material for generating thereon a third set of protuberances having the same density as the protuberances of said second set,

- coupling by means of adhesive to said first layer of web material at least said second layer of web material,

- wherein the adhesive is applied, prior to said

coupling of said first layer to said second layer, to a top surface of at least some protuberances of said third set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern, and

— wherein protuberances of said second set and said third set are inserted inside one another.

53. (New) The method according to claim 52 further comprising generating said first set of protuberances and said second set of protuberances on the first layer by running said first layer around a first pressure roller interacting with a first embossing cylinder and a second embossing cylinder that have respectively a first set of points and a second set of points, the second set of points being of larger dimension and lower density than the first set of points.

54. (New) The method according to claim 52 further comprising generating said first set of protuberances by embossing with a first embossing cylinder and a first pressure roller, and generating said second set of protuberances with a second pressure roller and a second embossing cylinder with which a third pressure roller interacts, the second embossing cylinder and the third

pressure roller generating said third set of protuberances on said second layer.

55. (New) The method according to claim 50 wherein said second layer of web material is provided with a background pattern made up of a set of protuberances.

56. (New) The method according to claim 55 wherein said background pattern of the second layer of web material is provided by embossing in-line and before coupling with the first layer of web material.

57. (New) The method according to claim 50, wherein said first layer and said second layer are separately embossed by corresponding first embossing units, which generate protuberances forming the background pattern on the first layer and the second layer, and are then run around a first embossing cylinder provided with points for generating said ornamental motif on the first layer and for joining the first layer and the second layer.

58. (New) The method according to claim 50 or 55, wherein said first layer and said second layer are joined together by a colored adhesive.

59. (New) The method according to claim 52 further comprising applying an adhesive to at least some protuberances of said third set on said second layer, and joining said first layer and said second layer by adhering the first layer and the second layer together, with

protuberances of said third set in correspondence with protuberances of said second set.

60. (New) The method according to claim 52 further comprising applying an adhesive to at least some protuberances of said third set on said second layer, and joining said first layer and said second layer by adhering the first layer and the second layer together, with protuberances of said third set in correspondence with protuberances of said second set.

61. (New) The method according to claim 52 further comprising embossing said second layer with a greater embossed depth than an embossed depth of the second set of protuberances on the first layer.

62. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern,

- embossing a second layer of web material for generating thereon a third set of protuberances having the same density as the protuberances of said second set,

- coupling by means of adhesive to said first layer of web material at least said second layer of web material,

- wherein the adhesive is applied to a top surface of at least some protuberances of said third set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern,

- wherein protuberances of said second set and said third set are inserted inside one another,

- wherein said first set of protuberances and said second set of protuberances are generated on the first layer by running said first layer around a first pressure roller interacting with a first embossing cylinder and a second embossing cylinder that have respectively a first set of points and a second set of points, the second set of points being of larger dimension and lower density than the first set of points,

- wherein said first layer and said second layer are joined together between the first pressure roller and the second embossing cylinder that interacts with the first pressure roller,

– wherein said second embossing cylinder interacts with a second pressure roller to generate a third set of protuberances on said second layer, and

– further comprising embossing said second layer with a greater embossed depth than an embossed depth of the second set of protuberances on the first layer.

63. (New) The method according claim 52 further comprising generating said first set of protuberances by a first embossing cylinder with a first pressure roller, and generating said second set of protuberances with a second pressure roller and a second embossing cylinder, with which a third pressure roller interacts, the second embossing cylinder and the third pressure roller generating said third set of protuberances on said second layer.

64. (New) The method according to claim 56 wherein protuberances of said background pattern on the first layer and protuberances of said ornamental motif on the first layer project toward said second layer, while said protuberances of said background pattern on the second layer project toward said first layer.

65. (New) The method according to claim 56 wherein said first layer and said second layer are separately embossed by corresponding first embossing units, which generate protuberances forming the background pattern on the first layer and the second layer, and are then run around an

embossing cylinder provided with points for generating said ornamental motif on the first layer and for joining the first layer and the second layer.

66. (New) The method according to claim 56 wherein said first layer and said second layer are joined together by a colored adhesive.

67. (New) The method according to claim 57 wherein said first layer and the said second layer are joined together by a colored adhesive.

68. (New) The method according to claim 64 wherein said first layer and said second layer are separately embossed by corresponding first embossing units, which generate protuberances forming the background pattern on the first layer and the second layer, and are then run around an embossing cylinder provided with points for generating said ornamental motif on the first layer and for joining the first layer and the second layer.

69. (New) The method according to claim 64 wherein said first layer and said second layer are joined together by a colored adhesive.

70. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of



protuberances, so as to generate on the first layer a second set of protuberances, which are higher than and partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern, said first set of protuberances and said second set of protuberances protruding from a common face of said first layer; and

- coupling by means of adhesive to said first layer of web material at least a second layer of web material,

- wherein the adhesive is applied, prior to said coupling of said first layer to said second layer, in areas corresponding to at least some protuberances of said second set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern, wherein the second set of protuberances are provided on the first layer before the first layer is joined to said second layer.

71. (New) The method according to claim 52 wherein the background pattern on said first layer of web material is provided by embossing in-line and before the embossing of said first layer for generating said ornamental motif.

72. (New) The method according to claim 52 wherein said first set of protuberances are generated on said first

layer by a first embossing cylinder, said third set of protuberances are generated on said second layer by a second embossing cylinder and said adhesive is applied thereon, while said second layer is in contact with said second embossing cylinder, said first layer is placed on said second layer while said second layer is still in contact with said second embossing cylinder, and said second set of protuberances are generated by laminating said first layer and said second layer on said second embossing cylinder.

73. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern, wherein the background pattern on the first layer of web material is provided by embossing in-line and before the embossing of the first layer for generating said ornamental motif,

- coupling by means of adhesive to said first layer of web material at least a second layer of web material,

wherein the adhesive is applied in areas corresponding to at least some protuberances of said second set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern,

- generating said first set of protuberances and said second set of protuberances on the first layer by running said first layer around a first pressure roller interacting with a first embossing cylinder and a second embossing cylinder that have respectively a first set of points and a second set of points, the second set of points being of larger dimension and lower density than the first set of points, and

- joining together said first layer and said second layer between the first pressure roller and the second embossing cylinder that interacts with the first pressure roller;

- wherein said second embossing cylinder interacts with a second pressure roller to generate a third set of protuberances on said second layer; and

- further comprising applying an adhesive to at least some protuberances of said third set on said second layer, and joining said first layer and said second layer by adhering the first layer and the second layer together, with

protuberances of said third set being in correspondence with protuberances of said second set.

74. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

- embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are partially superimposed on the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern,

- embossing a second layer of web material for generating thereon a third set of protuberances having the same density as the protuberances of said second set,

- coupling by means of adhesive to said first layer of web material at least said second layer of web material,

- wherein the adhesive is applied to a top surface of at least some protuberances of said third set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern,

- wherein protuberances of said second set and said third set are inserted inside one another,

— wherein said first set of protuberances and said second set of protuberances are generated on the first layer by running said first layer around a first pressure roller interacting with a first embossing cylinder and a second embossing cylinder that have respectively a first set of points and a second set of points, the second set of points being of larger dimension and lower density than the first set of points, and

— wherein said second embossing cylinder interacts with a second pressure roller to generate a third set of protuberances on said second layer.

75. (New) The method according to claim 74 further comprising applying an adhesive to at least some protuberances of said third set on said second layer, and joining said first layer and said second layer by adhering said first layer and said second layer together, with protuberances of said third set in correspondence with protuberances of said second set.

76. (New) A method for producing an embossed sheet material including at least two layers of web material joined together, comprising steps of:

— embossing a first layer of web material, previously provided with a background pattern made up of a first set of protuberances, so as to generate on the first layer a second set of protuberances, which are partially superimposed on

the first set of protuberances making up the background pattern, and defining an ornamental motif made up of a pattern of major dimensions and minor density with respect to the background pattern,

- embossing a second layer of web material for generating thereon a third set of protuberances having the same density as the protuberances of said second set,

- coupling by means of adhesive to said first layer of web material at least said second layer of web material,

- wherein the adhesive is applied to a top surface of at least some protuberances of said third set of protuberances, the sheet material being substantially free of adhesive in correspondence with protuberances of said first set of protuberances forming said background pattern,

- wherein protuberances of said second set and said third set are inserted inside one another,

- wherein said first set of protuberances and said second set of protuberances are generated on the first layer by running said first layer around a first pressure roller interacting with a first embossing cylinder and a second embossing cylinder that have respectively a first set of points and a second set of points, the second set of points being of larger dimension and lower density than the first set of points, and

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— wherein said second layer is embossed with a greater embossed depth than an embossed depth of the second set of protuberances on the first layer.